



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

649.4819

Job Sheet 165848



Part No: 649.4819

Job Qty: 20 pcs

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/6/17

Job Tracking No:

Due Date: 10/20/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C

Ship Via:

S002114

17.11.14

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	20 Ea	10/20/17	0.00	0.00	Start up container	
110	Waterjet	20 pcs	10/20/17	0.00	0.00	Waterjet1	
120	QC	20 pcs	10/20/17	0.00	0.00	QC2	
130	QC	20 pcs	10/20/17	0.00	0.00	QC8	
140	Outsource	20 pcs	10/20/17	0.00	0.00	Outsource4	
150	Packaging	20 pcs	10/20/17	0.00	0.00	Packaging2	
160	QC	20 pcs	10/20/17	0.00	0.00	QC5	
170	Packaging	20 pcs	10/20/17	0.00	0.00	Packaging3	
180	QC	20 pcs	10/20/17	0.00	0.00	QC21	

1.5 mil thickness primer

SP (20) DAS 38

9-89

17/11/14

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.080	1	75	0	0

Part Specifications

Specifications could not be found.

Plex 10/6/17 10:34 AM Dart.lajeunesse.marie

Status: Stock

ATG

Part: **649.4819 B165848**

Created: 9/30/17 10:58 AM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: **S000021**

Printed By: Goldston, Justin 10/2/17 10:44 AM

DART
AEROSPACE
S004305



Shim

PART NO: 649.4819
Revision:
Operation: Outsource
Quantity: 20
Change No:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 10/31/17

Job No: 165848

Work Order ID 165848

Thursday, August 31, 2017 11:00:04 AM

165848

Page 1

Item ID: 649.4819 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 8/31/2017 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 9/22/2017 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 31 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
649.4800	c								

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Debutr if necessary

0.00

(20)

17/09/07

DAS
40
9-89

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

(20)

17/09/07

DAS
40
9-89

20x SPN-10-30

Work Order ID 165848

Thursday, August 31, 2017 11:00:04 AM

165848

Page 3

Item ID: 649.4819

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 8/31/2017

Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/22/2017

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

20

DAS
38
9-88

NOV 09 2017

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Thursday, August 31, 2017 11:00:07 AM

Work Order ID: 165848

165848

Parent Item: 649.4819

649 4819

Parent Item Name: Shim

Start Date: 8/31/2017

Required Date: 9/22/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 17.08.30 NEW ISSUE DD VRF:DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased			No	110	sf	42.1000	0.055	1.157895			
M2024T3S 080									**			17/09/07	DAS 40 9-89
2024-T3 .080 sheet													

Location

Loc Qty

Loc Code

MAT021

42.1

M127668

4

M136342

6.4

M136896

3

M137980

28.7

2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

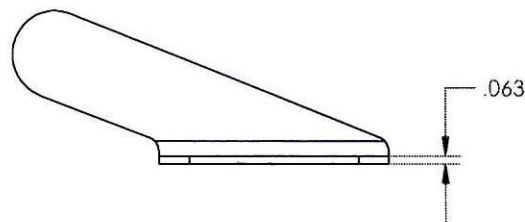
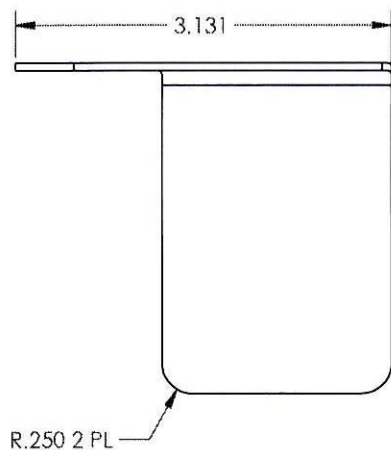
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

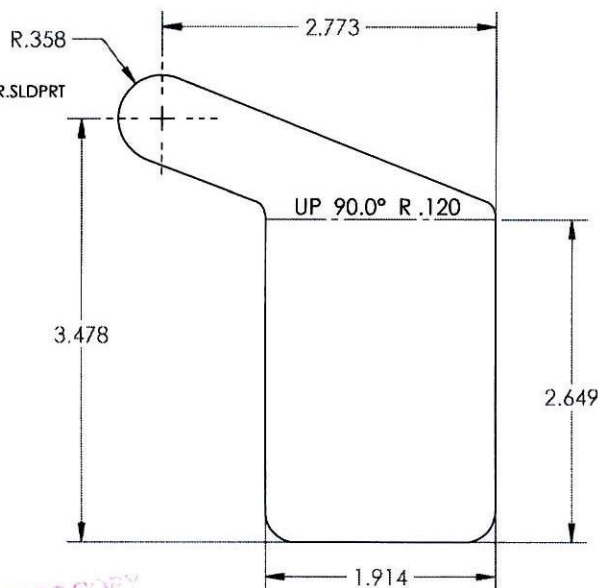
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NOTES: UNLESS OTHERWISE SPECIFIED

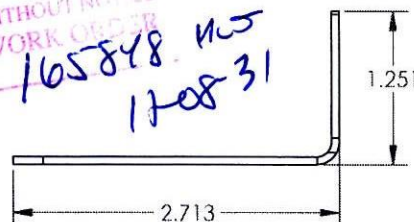
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
- 5 PART DIMENSIONS CONTROLLED BY CAD MODEL: FILE NAME: 649.4816 DOUBLER.SLDPR
6. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.



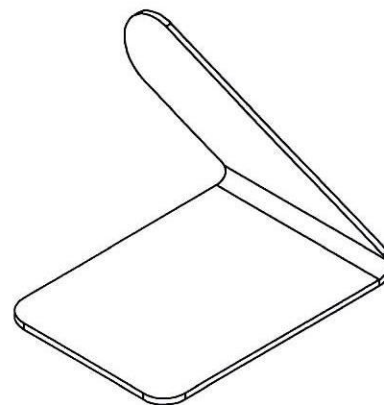
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165848 NCS
120831



649.4811
FLAT PATTERN



REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		
N/C	INITIAL RELEASE	11-03-11	P. BRAVO
A	INCORPORATED ECH 03475	04-11-12	P. BRAVO
B	INCORPORATED ECH 05502	07-26-14	P. BRAVO
C	INCORPORATED ECH 05801	07-26-17	P. BRAVO



649.4811

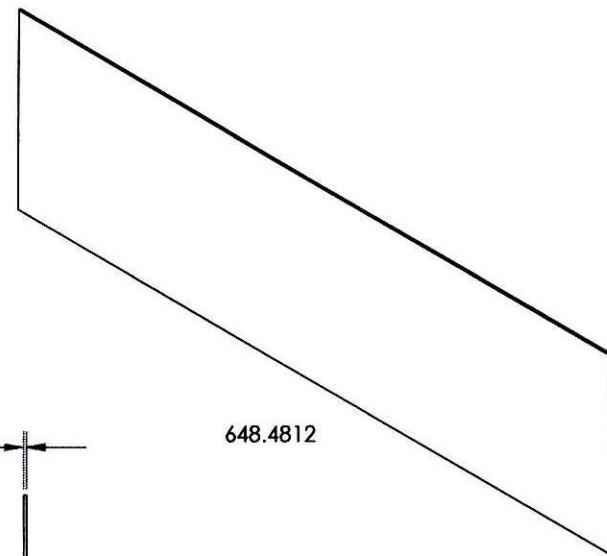
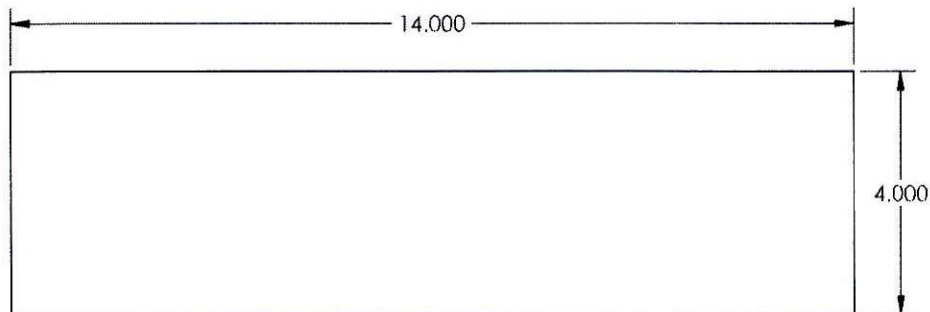
FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
10	649.4819	SHIM	△	△
9	649.4818	SHIM	△	△
8	649.4817	SHIM	△	△
7	649.4816	DOUBLER	△	△
6	649.4815	SHIM	△	△
5	649.4814	DOUBLER	△	△
4	649.4813	SHIM	△	△
3	649.4812	SHIM	△	△
2	649.4811	CLIP	△	△
1		DELETED		

QTY	DESCRIPTION	PARTS LIST
NEXT ASSY (S)	649.4700	
ORIGINAL DATE: 11-03-11 DRAWN BY: T. CHESTER A. QUAN P. BRAVO DRAWING APPROVAL: P. BRAVO 11-03-11 CONTRACTING		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .003 2 PLACE DECIMALS ± .010 ANGLES ± .5°		
SHEET	CAGE CODE	DWG. NO.
B	07M26	649.4800
SCALE	NONE	SHEET 1 OF 7

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760) 724-5300

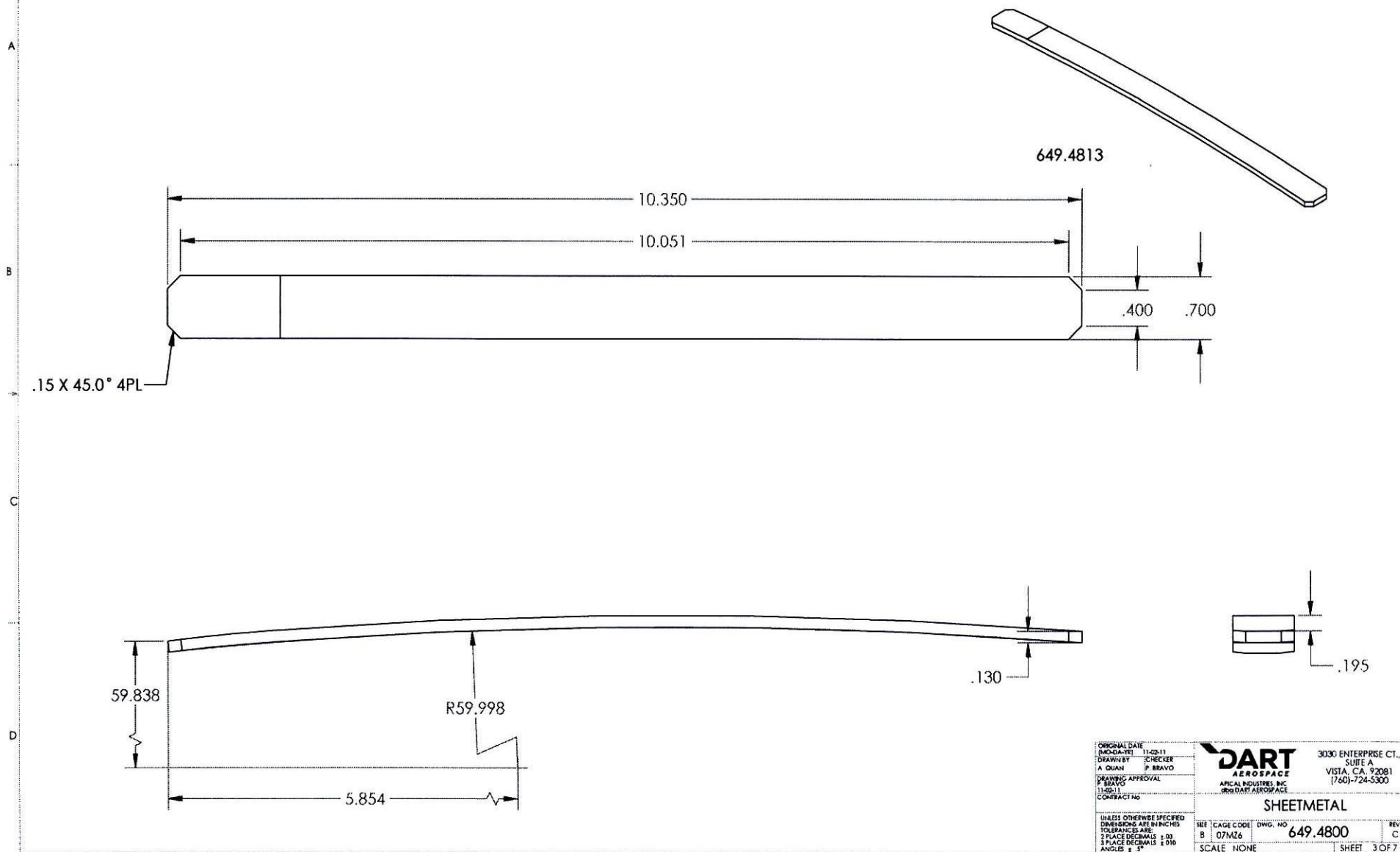
SHEETMETAL

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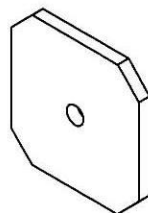
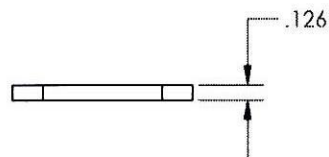
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DRAWN BY: C. HEEVER A. QUAN		P. BRAVO	
DRAWING APPROVAL P. BRAVO (11-05-11)		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SHEET 8 CAGE CODE 07MZ6 SCALE NONE	DWG NO. 649.4800 REV. C SHEET 2 OF 7

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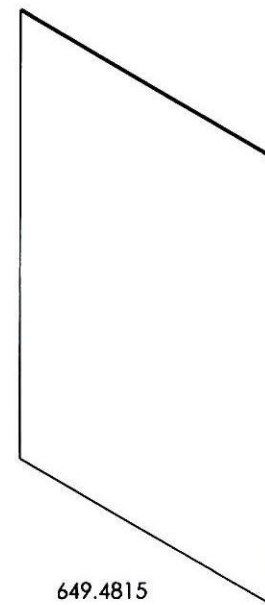
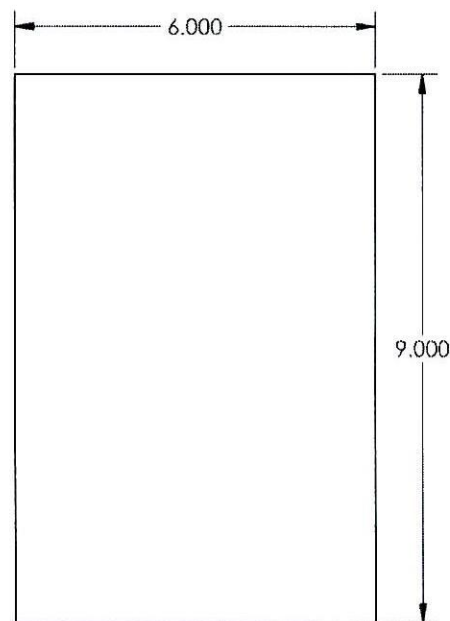
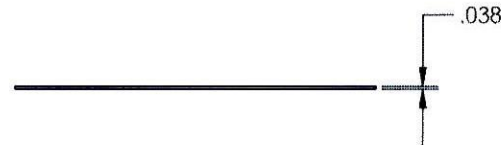


ORIGINAL DATE (MM-DD-YY) 11-02-11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY: SCHNEIDER A QUAN P BRAVO		DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P BRAVO 11-02-11 CONTRACTING		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		REV B 07M26	REV C
SCALE NONE		DWG. NO 649.4800	
		SHEET 3 OF 7	

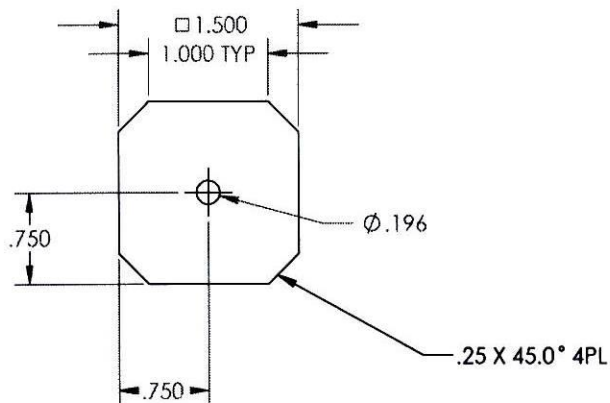
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649.4814



649.4815



ORIGINAL DATE (MO-DA-YR) 11-03-11		3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY: T-CHECKER A. QIAN P. BRAVO		APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO (11-03-11)		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		REV. C	REV. C
DWG. NO. 649.4800	SCALE NONE	SHEET 4 OF 7	

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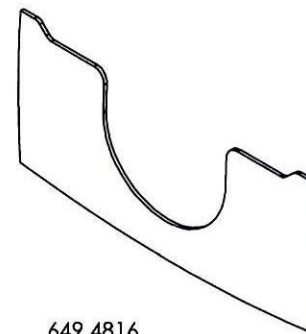
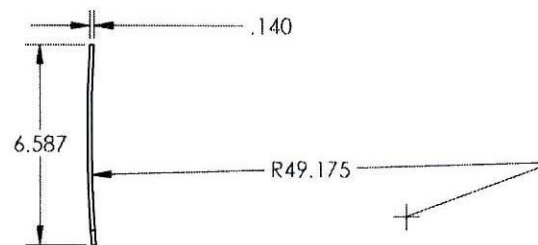
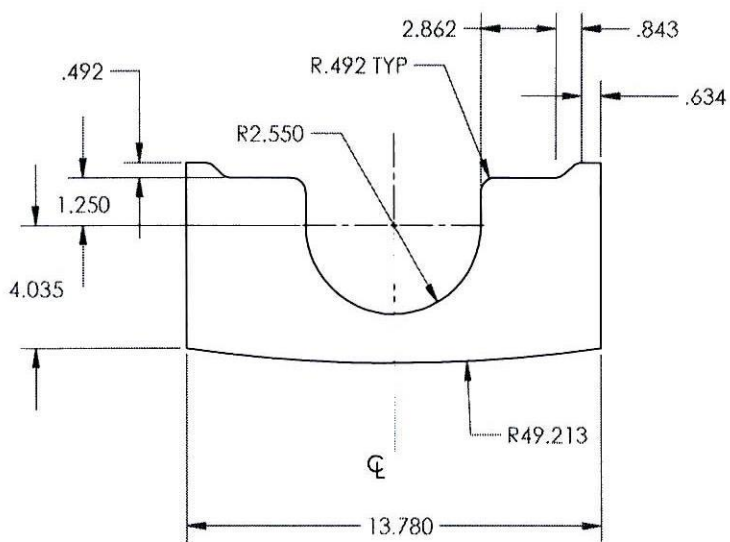
A

B

C

C

D



ORIGINAL DATE (MO-DA-YR) 11-03-11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY: CHECKER A. QIAN P. BRAVO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 11-03-11		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SHEET 8 CAGE CODE 07MZ6 SCALE NONE	DWG. NO. 649.4800 REV. C SHEET 5 OF 7

1 2 3 4 5 6 7

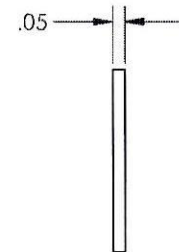
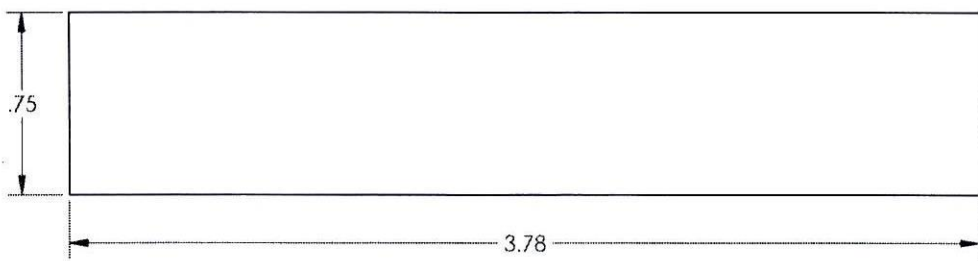
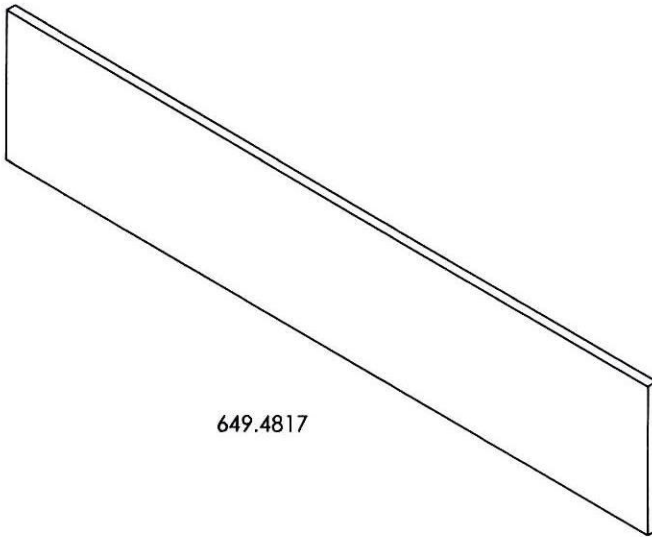
A

B

C

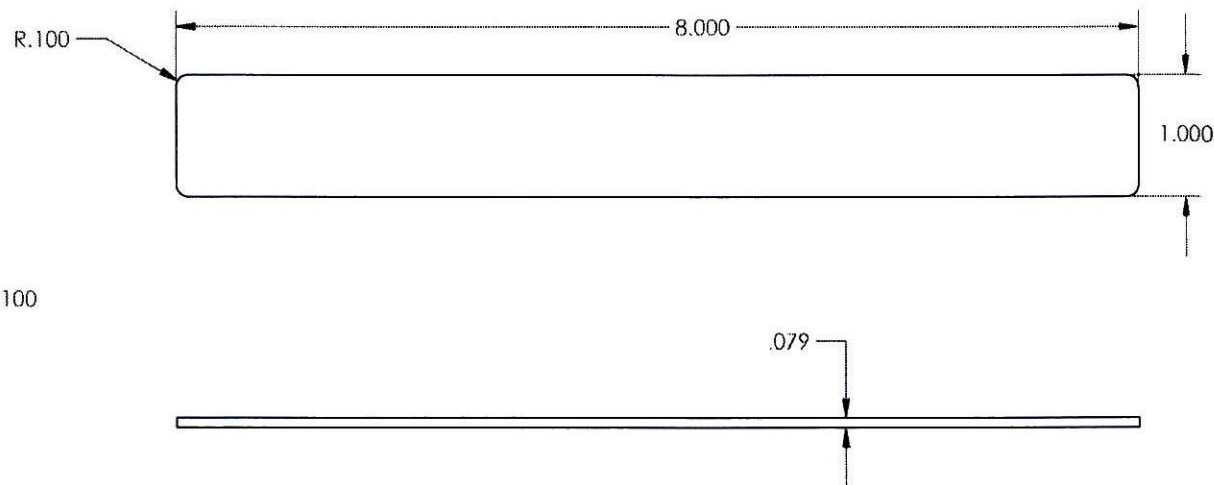
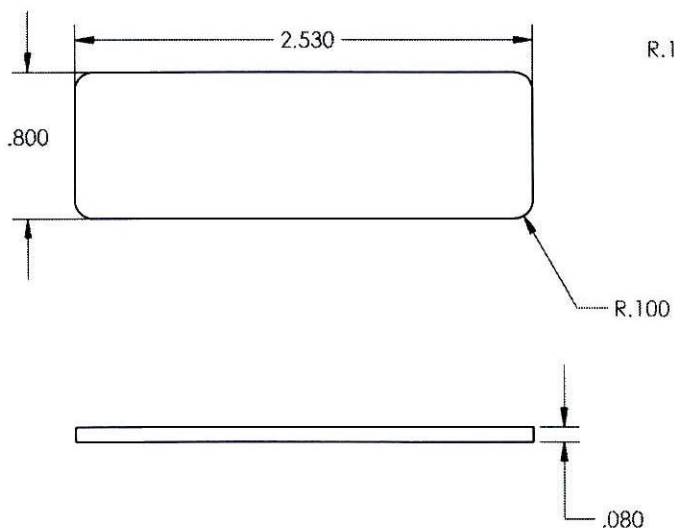
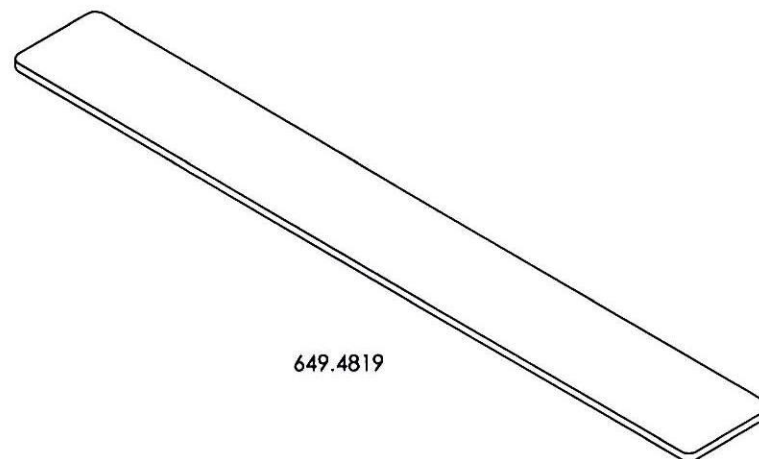
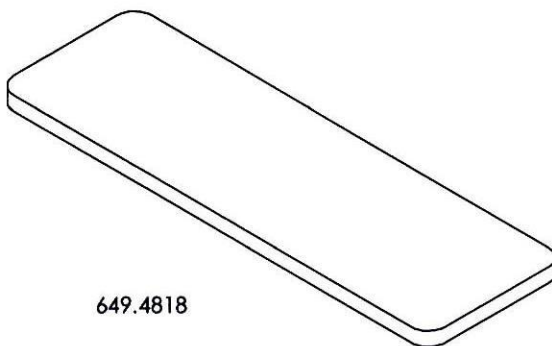
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ORIGINAL DATE (MO-DA-YR) 11-02-11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY A. QUAN		CHECKED P. BRAVO	
DRAWING APPROVAL P. BRAVO (11-06-11)		APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± 5°		SIZE B	CAGE CODE 07MA26
		DWG. NO. 649.4800	REV C
		SCALE NONE	SHEET 6 OF 7

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ORIGINAL DATE (MO-DA-YR) 11-03-11		DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY: J. CHELIER A. QUAN P. BRAVO					
DRAWING APPROVAL P. BRAVO (11-03-11)		CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± 5°		SIZE B	CAGE CODE D7MZ6	DWG. NO. 649.4800	REV. C
SCALE: NONE		SHEET 7 OF 7			



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038153

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	165676	RBEM533V5000101-7	-	BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 - Certificate of Conformity is required Handle Leg -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 - Certificate of Conformity is required		Firmed	10/26/17	1 pcs	0 pcs	1 pcs	\$13.4433/pcs	\$13.44
9	165434	RBEM533V5000101-7	-	Handle Leg -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 - Certificate of Conformity is required		Firmed	10/26/17	1 pcs	0 pcs	1 pcs	\$13.4433/pcs	\$13.44
10	166065	646.9813	-	Lower Deflector Low Issue P/O to ATG :		Firmed	10/26/17	8 pcs	0 pcs	8 pcs	\$13.2333/pcs	\$105.87
11	165155	647.0110	-	Roof Doubler Issue P/O to ATG : 1- Black Anodize as per Dwg 647.0100		Firmed	10/26/17	18 pcs	0 pcs	18 pcs	\$45.0833/pcs	\$811.50
12	165590	649.5014	-	Deflector		Firmed	10/26/17	4 pcs	0 pcs	4 pcs	\$37.3333/pcs	\$149.33
13	165848	649.4819	-	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) C OF C IS REQUIRED		Firmed	10/26/17	20 pcs	0 pcs	20 pcs	\$37.3333/pcs	\$746.67
14	165847	649.4818	-	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)		Firmed	10/26/17	10 pcs	0 pcs	10 pcs	\$8.633/pcs	\$86.33

20x

SPT 10-30

DAS
30
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913990

Date: 11-Oct-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: D4842-1 Lower Cutter Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 21718	Rev: B PO: PO37769	Line: 1
10 ea	Part: 649.4818 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21730	Rev: C PO: PO37769	Line: 13
20 ea	Part: 649.4819 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21731	Rev: C PO: PO37769	Line: 14
8 ea	Part: 646.9813 Lower Deflector Low Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 21732	Rev: A PO: PO37769	Line: 15
1 ea	Part: ADMINISTRATION FEE Administrative Fee Job: 21808	Rev: N/A PO: PO37769	Line: 16-17
		Made in Canada.	

DAS
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9-89

SP A-10-30

SP A-10-11



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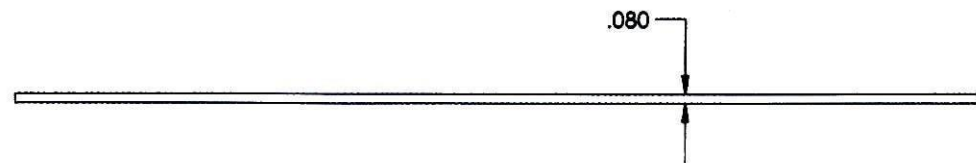
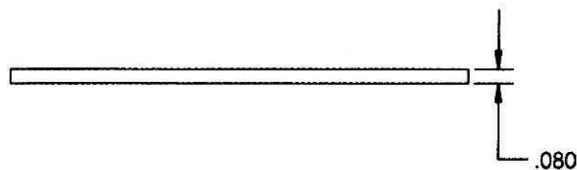
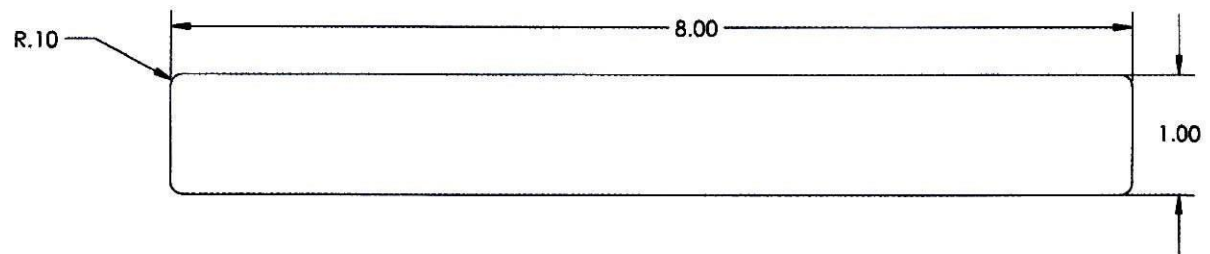
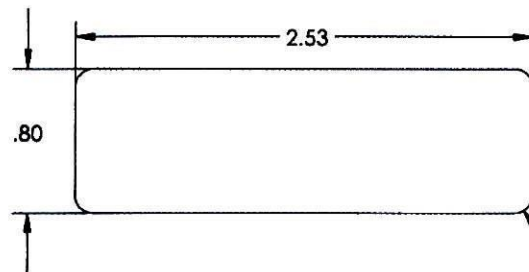
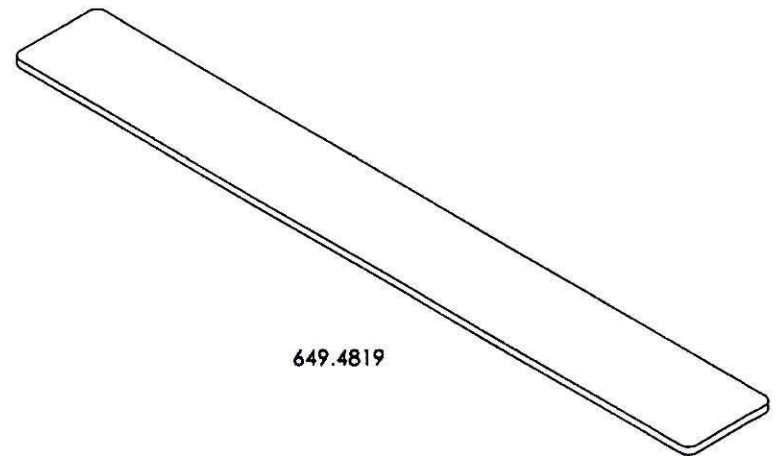
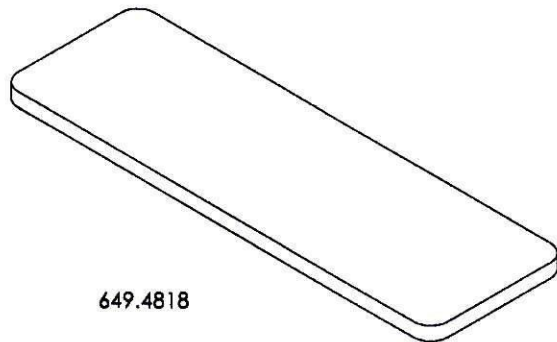
Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
6 ea	Part: 647.4110 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21726	Rev: N/C3	PO: PO37769 Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/10/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

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ORIGINAL DATE 11-02-11		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. GUAN	CHECKED P. BRAYO	DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAYO 11-02-11			
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .020 3 PLACE DECIMALS .010 ANGLES .5°		REV B	REV D
SEE B	CAGE CODE 07MA26	DWG NO. 649.4800	SCALE NONE
			SHEET 7 OF 8